



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4011-1
Job Sheet 189956-A



Part No: D4011-1

Job Qty: 35 pcs

Part Name: Clamp, Short



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/11/19

Job Tracking No:

Created By: Linda Lacelle

Due Date: 2/15/19

Type: SOLD

Description:

Note: DWG REV C IPP RevA: New issue DD verified by:EC IPP Rev:B 11.05.19 MADE IN HOUSE DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
120	QC 8	35 pcs		2/15/19	0.00	0.00	QC 8 - 1 (A)			
130	Small Fab - Brake NC - B4B	35 pcs		2/15/19	0.02	1.78	Small Fab - Brake - 1 - B4B		DAS 30 9:00	APR 1
							Small Fab - Brake - 2 - B4B			
							Small Fab - Brake - 3 - B4B			
140	QC 5	35		2/15/19	0.00	0.00	QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 42			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
							QC 5 - 40			
150	Packaging 3-1 - Stock - B4B	35 pcs		2/15/19	0.00	0.00	Packaging 3 - 1 - B4B		DAS 40 9:00	APR 11 2019
							Packaging 3 - 2 - B4B			
							Packaging 3 - 3 - B4B			
							Packaging 3 - 4 - B4B			
							Packaging 3 - 5 - B4B			
							Packaging 3 - 6 - B4B			
							Packaging 3 - 7 - B4B			

<



Container No: S161080



Part: D4011-1

Job No: 189956-A

Serial No/Batch: S154390

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/10/19

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DAS
40
9-89
APR 11 2019

2019

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	54544
				Packaging 3 - 28 - B4B	87 APR 11 2019
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	35 pcs	2/15/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	APR 11 2019
				QC 21 - SA - 53	DAS 70 9-89
Part Op 120 - (QC8- Inspect parts - second check) Descriptions: 130 - (Form as per dwg) 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Identify as per dwg & Stock Location: _____) 160 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Job BOM records could not be found.					
Job Allocations					
Job Allocations could not be found.					

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp, Short	0.266Inches + 0.006 - 0.001	0.272 0.265	Diameter	
2	Clamp, Short	0.328Inches ± 0.010	0.338 0.318		
3	Clamp, Short	0.750Inches ± 0.030	0.780 0.720		
4	Clamp, Short	1.000Inches ± 0.030	1.030 0.970		
5	Clamp, Short	1.250Inches ± 0.030	1.280 1.220		
6	Clamp, Short	0.250Inches ± 0.030	0.280 0.220		
7	Clamp, Short	0.130Inches ± 0.030	0.160		

			0.100
8	Clamp, Short	4.490Inches $\pm$ 0.030	4.520 4.460
9	Clamp, Short	1.800Inches $\pm$ 0.030	1.830 1.770
10	Clamp, Short	6.454Inches $\pm$ 0.010	6.464 6.444
11	Clamp, Short	7.270Inches $\pm$ 0.010	7.280 7.260
12	Clamp, Short	8.080Inches $\pm$ 0.030	8.110 8.050
13	Clamp, Short	0.080Inches $\pm$ 0.010	0.090 0.070

Plex 3/11/19 10:45 AM dart.lacelle.linda



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D4011-1**Job Sheet 189956****Part No:** D4011-1**Job Qty:** 60 pcs**Part Name:** Clamp, Short**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/1/19**Job Tracking No:****Due Date:** 2/15/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG REV C IPP RevA: New issue DD verified by:EC IPP Rev:B 11.05.19 MADE IN HOUSE DD verified by:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	60 pcs	2/15/19	2/15/19	0.00	2.67	Waterjet - Omax		02/19/02/15
120	QC 8	60 pcs	2/15/19	2/15/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 38		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
130	Small Fab - Brake NC - B4B	60 pcs	2/15/19	2/15/19	0.02	3.05	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 - B4B		
140	QC 5	60 pcs	2/15/19	2/15/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		

DAS 40
9-89

DAS 9
3-89

19.02.20

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				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
150	Packaging 3-1 - Stock - B4B	60 pcs	2/15/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
160	QC 21 - SA	60 pcs	2/15/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70

Part Op 100 - 1-Cut as per Dwg Dwg Rev: C Prog Rev: C 2-Deburr if necessary

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - (Form as per dwg)

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Identify as per dwg & Stock Location: _____)

160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	4.8000 sf (.08 ea)	100-Waterjet - Omax - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	M304S14GA	5	1	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp, Short	0.266Inches + 0.006 - 0.001	0.272 0.265	Diameter	
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					